

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001508**Date Inspected:** 04-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Le Feng, Ye Yong Jun, Sha Zi Cui, Wu Yuesong			CWI Presenting	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** Tower Mock-ups and OBG**Summary of Items Observed:**

The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

Tower Fabrication Facility**89M Mock-up Assembly**

The Quality Assurance Inspector generated an incident report pertaining to non continuous backing and tack welds on backing not welded the full length of the backing on corner stiffener assemblies. See Caltrans Incident Report dated 2-4-08 for further information.

The Quality Assurance Inspector observed ZPMC performing cutting operations on there cutting table utilizing a natural gas and oxygen mix, cutting diaphragm plates identified as P306 and P414 for the 23M elevation.

Bay 1

The Quality Assurance Inspector observed ZPMC squaring the length of closed ribs on the milling machine. Eight ribs were stacked and being milled simultaneously. The Quality Assurance Inspector measured the ribs to be approximately five meters in length, 12 millimeters in thickness and 790 millimeters in width. The Quality Assurance Inspector observed ZPMC drilling bolt holes in the closed ribs. ZPMC was observed beveling closed ribs in preparation for the partial joint penetration connection to the deck plate. ZPMC Quality Control would measure the bevel angle and record the values on the closed rib. The general appearance of the bevel appeared to be rough and contain sharp edges. ZPMC was observed bending closed ribs and performing dimensional inspections. On a previous date an incident report was generated pertaining to the use of three steel rulers in an

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

attempt to measure the height of the closed ribs. The Quality Assurance Inspector observed ZPMC using a caliper type device to measure the height of the ribs providing a more accurate value. Below is a digital photograph illustrating the device.

Bay 2

The Quality Assurance Inspector observed ZPMC grinding the transition welds at skin C in preparation for fitting up interior bolted connection plates on the 114M lower Mock-up. In addition ZPMC was observed drilling 30 millimeter bolt holes on interior bolted stiffener connection plate A69.

Bay 3

The Quality Assurance Inspector witnessed ZPMC Quality Control performing visual inspection to Bottom Plate 013. ZPMC marked several tack welds for repair. The tack welds appeared to contain centerline cracks.

Bay 7 and 8

The Quality Assurance Inspector observed no ZPMC personnel working in bays 7 and 8.



Summary of Conversations:

As stated in the contents of the above report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Bertlesman,Greg	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
